

Date: Tuesday, 12/5/2006 8:14:48 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 6" MIRROR		
Job Number	: 29773		Part Number	: D2011101		
Estimate Number	: 10101		Drawing Number	: D2011 REV. F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/5/2006 S.O. No. : N/A		Drawing Revision	: F		
Prsht Rev?	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/23/2006 Qty: 50 Um: Each		
Previous Run	: 27163					
Written By	: <i>[Signature]</i>					
Checked & Approved By	: <i>[Signature]</i>					
Comment	: Est: J 04.09.15 Added Steps 5-7 Est: K 05.12.15 chg black sikaflex for white		KJ/JLM	EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
<b>Comment:</b> PURCHASING Issue P/O: <u>2639</u> <i>2639/12/06</i> Purchase Grote Mirror P/N: 28043 Possible supplier: UAP/NAPA Material release note required		
2.0	28043	MIRROR 6" 
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Mirror 6"		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK 
<b>Comment:</b> DIMENSIONAL CHECK <i>12/5/11 SG QSP09</i>		
5.0	D30141	Locknut 

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Locknut

Pick:

Qty Part Number Description Batch

1 D3014-1 Lock nut *B25021*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 6" MIRROR	
Job Number: 29773		Part Number: D2011101	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
6.0	AN960JD416L	Washer 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Washer Pick: Qty Part Number Description Batch 1 AN960JD416L Washer <i>M101237</i>		<i>SAD 06/12/21</i>	
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Discard Hardware & Install new hardware loosely 2- Drill mirror using drill Jig DT8704 as per Dwg D2011 3- Inject 3ml of Sikaflex -291/-241adhesive per hole.			
Qty	Part Number	Description	Batch
9ml	N/A	Sikaflex-291/-241	<i>410210738</i>
Expiry date		<i>02/2007</i>	
4- Test assembly to 50lbs pull test after 24 hours Start: <i>06/12/21</i> Time: <i>1:30</i> Finish: <i>07/01/16</i> Time: <i>2:50</i>		<i>M1026727</i> <i>02/2007</i> <i>SAD 06/12/21</i>	
8.0	QC5 	INSPECT WORK TO CURRENT STEP 	(P)
Comment: INSPECT WORK TO CURRENT STEP		<i>07/01/16 (50)</i>	
9.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST198</i>		<i>07/01/16 (90)</i>	
10.0	QC21 	FINAL INSPECTION/W/O RELEASE 	(50)
Comment: FINAL INSPECTION/W/O RELEASE		<i>07/01/16</i>	
Job Completion 		<i>07/01/16</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.16	8.0	Test ASS'Y to 50Lbs pull test. move AT QC 5 perm. change. <i>J</i>	<i>E</i>	07.01.16		<i>07.01.16</i>	<i>07.01.16</i>

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: *D* Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

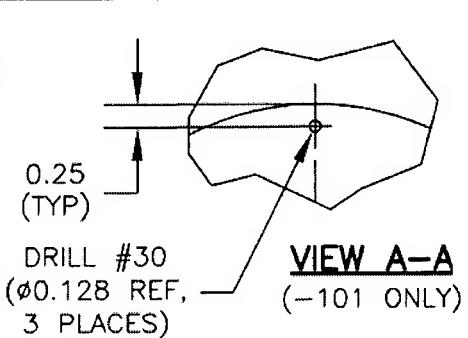
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

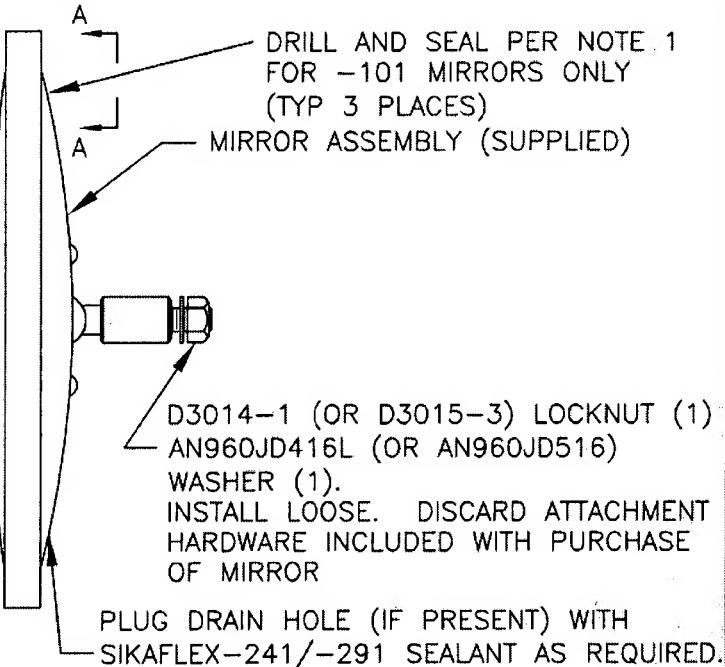
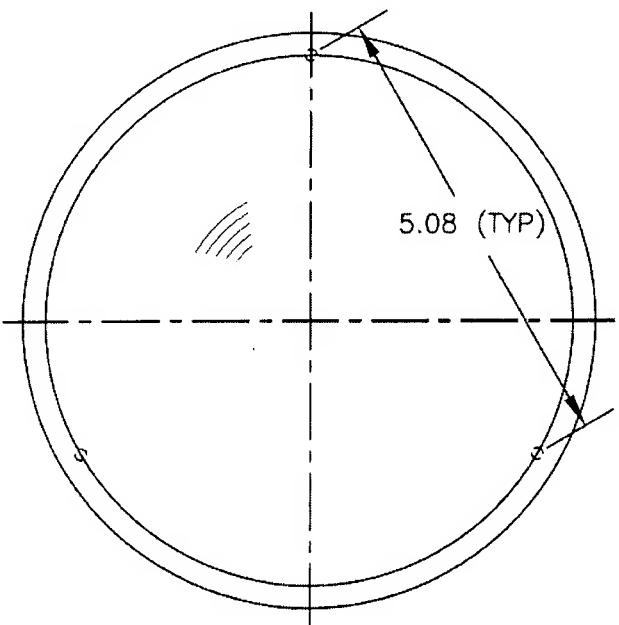
**DART**

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2011 REV. F SHEET 1 OF 1
DATE		TITLE MIRROR ASSEMBLY SCALE 1:2
04.09.10		



-	90.03.31	NEW ISSUE
A	90.06.15	DWG NO. WAS DSP1011, ADDED -103
B	98.04.09	SIKAFLEX 241 ADDED
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD
E	01.05.08	NEW 8" MIRROR
F	04.09.10	ADD HOLES FOR SEALANT ON -101

RELEASED  
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
1		D3015-3	LOCKNUT
1		AN960JD516	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29773

## NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

Copyright © 1990 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



HAWKESBURY AUTO PARTS INC 5580661# 861597896RTO001  
4 MAIN STREET WEST EXCH:SU 6259 EXP:03/12/31  
HAWKESBURY, ONT. K6A 2J2  
TEL: 632-8575 FAX: 632-1539

DANGEROUS GOODS PERMIT  
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS  
CANUTEC 613-996-6666

ACCT #	SOLD TO		DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET		12/08/06	14:134	060004074	31	143493
SR #	HAWKESBURY, ONTARIO						
6	K6A 1K7						
AD							
	PURCHASE ORDER #		ATTENTION				
	2559		6122-5207				
	TAX EXEMPTION:		30 DAYS				
	TERMS:		CHARGE SALE				
	DELIVERY:						
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL	
28043	GRO	GROTE	50.00	41.140	16.820	841.00	T150

REFUNDED BY \_\_\_\_\_

Subtotal 841.00

VERIFIED BY \_\_\_\_\_

Tax 6% GST ONLY 50.46

Tax 0% 0.00

*Robert Mararden*

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE 891.46